

**CLAIMS:**

1. (currently amended) A yarn suitable for weaving into fabric, the yarn comprising an inner portion of spun staple fibers of ~~recycled plastic post consumer recycled (PCR) polyethylene terephthalate (PET)~~ formed from a pre-extruded liquid polymer insufficiently pure to pass through a twenty micron opening without clogging it and an outer portion comprising a different material, ~~the outer portion covering from 70% to 100% of the surface of the inner portion.~~
2. (canceled).
3. (canceled).
4. (previously presented) The yarn of claim 1 wherein the plastic comprises at least about 30 percent by weight of the yarn.
5. (previously presented) The yarn of claim 1 where the outer portion comprises fibers selected from the group consisting of fire retardant fibers, moisture management fibers, bacterial resistant fibers, ultraviolet ray resistant fibers, low surface friction fibers, textured fibers, nylon, aramid, and natural fibers.
6. (previously presented) The yarn of claim 1 further comprising a continuous filament core.
7. (original) The yarn of claim 6 wherein the core comprises a high tenacity material having a tenacity greater than five grams per denier.
8. (original) The yarn of claim 7 wherein the core has a tenacity between 8 and 35 grams per denier.
9. (original) The yarn of claim 6 wherein the core has a texturized surface.

10. (original) The yarn of claim 6 wherein the core is corespun, the core comprising at least one continuous filament and spun staples surrounding the filament.
11. (original) The yarn of claim 6 wherein the core is a stretch material.
12. (previously presented) The yarn of claim 1 wherein the yarn is a fasciated yarn.
13. (previously presented) The yarn of claim 1 wherein the outer portion comprises spun staple fibers.
14. (previously presented) The yarn of claim 1 wherein the outer portion comprises a continuous helically wrapped cover yarn.
15. (original) The yarn of claim 14 wherein the cover yarn comprises a continuous filament.
16. (original) The yarn of claim 15 wherein the cover yarn is a monofilament.
17. (currently amended) The yarn of claim 15 wherein the outer portion comprises two helically wrapped cover yarns, wrapped in opposite directions.
18. (original) The yarn of claim 15 wherein the cover yarn comprises a spun yarn.
19. (canceled).

20. (currently amended) A yarn comprising an inner portion of spun staple fibers of post consumer recycled (PCR) polyethylene terephthalate (PET) formed from a pre-extruded liquid polymer insufficiently pure to pass through a twenty micron opening without clogging it and an outer portion comprising an inner helix and an outer helix formed of a material different from the inner helix.

21. (original) A yarn comprising two spun staple fibers of different material, the first staple fibers being longer than the second staple fibers, the second staple fibers forming a major part of the surface of the yarn.

22. (original) A yarn comprising a core formed of at least one strand of a continuous filament having a tenacity of at least about five grams per denier, a sheath of staple fibers surrounding the core, and a cover comprising an inner helix and an outer helix.

23. (original) The yarn of claim 22 wherein the sheath comprises PCR plastic.

24. (original) The yarn of claim 23 wherein the PCR plastic is PET.

25. (previously presented) The yarn of claim 22 wherein the outer helix is formed of a material different from the inner helix.

26. (previously presented) A fabric woven or knitted of the yarn of claim 22.

27. (original) The fabric of claim 26 wherein the fabric has a tensile strength greater than that of a fabric formed of the core material of a denier equal to the denier of the yarn.

28. (currently amended) A method of forming a yarn containing staple fibers of PCR plastic formed from a pre-extruded liquid polymer insufficiently pure to pass through a twenty micron opening without clogging it, comprising spinning a plastic-surfaced yarn from the staple fibers of PCR plastic, and thereafter forming a cover over the plastic surfaced yarn with a cover wrapping machine or an air jet machine.

29. (previously presented) A yarn comprising a high strength fasciated yarn comprising two spun staple fibers of different materials, the first being synthetic and

not moisture absorbent and longer than the second fibers, the second fibers forming a major part of the yarn surface.

30. (original) A method of producing a spun yarn comprising two layers of sheath over a continuous core, the method comprising simultaneously feeding two different staple fibers into a spinning device to simultaneously form the two layers over the core, one of the layers being predominantly one of the staple fibers, and the other layer being predominantly the other.

31. (original) The method of claim 30 wherein the staple fibers are fed through a T-trumpet.

32. (previously presented) The method of claim 30 wherein one of the fibers is a PCR plastic and predominates in an inner layer over the core.

33. (original) The method of claim 32 wherein the other fiber is selected from the group consisting of fire retardant fibers, moisture management fibers, bacterial resistant fibers, ultraviolet ray resistant fibers, low surface friction fibers, textured fibers, high tenacity nylon, aramid, and natural fibers.

34. (previously presented) The method of claim 33 wherein the other fiber is a natural fiber.

35. (previously presented) A method of producing a spun yarn comprising two layers of sheath over a continuous filament core, the method comprising forming an intermediate yarn by feeding a first staple fiber into a spinning device to form a sheath of the first staple fiber over the core, and thereafter feeding a second staple fiber into a spinning device to form a sheath of the second staple fiber over the intermediate yarn.

36. (original) The method of claim 35 wherein the first staple fiber is a PCR plastic.

37. (original) The method of claim 36 wherein the PCR plastic is PCR- PET.

38. (previously presented) The method of claim 35 wherein the second fiber comprises a natural fiber.

39. (original) The method of claim 33 wherein the second fiber is cotton.

40. (currently amended) A corespun yarn comprising a core and two sheaths over the core, the first sheath being formed of spun staple fibers of different compositional makeup than the second sheath, the second sheath comprising a minor portion of the material of the first sheath in addition to at least one other material.

41. (canceled).

42. (currently amended) A method of producing a yarn comprising a core, a sheath, and a cover, the method comprising forming an intermediate yarn by feeding a first staple fiber into a spinning device to form a sheath of the first staple fiber over the core, and thereafter feeding the intermediate yarn into a cover wrapping machine or an air jet machine to form forming at least one helix of a continuous yarn around the intermediate yarn.

43. (original) The method of claim 42 wherein the first staple fiber comprises PCR-PET.

44. (previously presented) The method of claim 41 comprising forming an inner helix and an outer helix around the intermediate yarn.

45. (original) A continuous and multi-filament yarn having a total denier of 12-800 and comprising 10-90% by weight of continuous high tenacity and high modulus

monofilaments having a tenacity higher than 15 and a modulus higher than 500, intermingled with continuous lower tenacity and lower modulus monofilaments having a tenacity between 5 and 15.

46. (original) A yarn comprising a core of the yarn of claim 45 and a sheath of spun staple fibers.

47. (original) The yarn of claim 46 wherein the sheath comprises recycled plastic staple fibers, the yarn further comprising an outer spun covering.

48. (original) A fabric comprising a ripstop grid of the yarn of claim 45.

49. (currently amended) A yarn comprising an inner portion of spun staple fibers of recycled plastic post consumer recycled (PCR) polyethylene terephthalate (PET) formed from a pre-extruded liquid polymer insufficiently pure to pass through a twenty micron opening without clogging it and an outer portion comprising a continuous filament helix two helically wrapped cover yarns, wrapped in opposite directions, the outer portion covering from 70% to 100% of the surface of the inner portion.

50. (previously presented) The yarn of claim 49 further comprising a continuous filament core.

51. (new) The yarn of claim 17 wherein the outer portion covers from 70% to 100% of the surface of the inner portion.

52. (new) The method of claim 28 wherein the cover is formed over the plastic surfaced yarn with a cover wrapping machine.